

AI-1700

Specifications

AS/NZS 2717.1 - 1984 (ES4-GM-W503H) (ES4-GC-W503H)

AWS/ASME A5.18-79, ER70S-6

BS2901 Part1-1963A18

Description and Applications

AI-1700 is a sound GMAW wire that provides the welder with high deposition rates and recovery rates up to 95 per cent. The wire is precision layer wound and copper coated for trouble-free feeding.

Applications: **AI-1700** can be used for both dip transfer and spray transfer.

Typical Weldmetal Analysis

C	Mn	Si	S	Fe	P
0.10	1.30	0.75	0.015	Bal	0.015

Mechanical Properties of Weldmetal

	As Welded
Yield Stress	400MPa
Tensile Strength	520MPa
Elongation	32%
Reduction Area	70%
Impact (Charpy V Notch)	80J at -20°C
Shielding Gas	Argoshield 50 or 51 Welding CO₂

Welding Parameters

Diameter (mm)	Current type	Amps
0.9	DC +ve	150-220
1.2	DC +ve	180-250
1.6	DC +ve	200-280

Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G) Horizontal vertical position, (4F) Horizontal overhead position, (4G) Overhead position, (3G, 3F, 5G up) Vertical Position Up & (3G, 3F, 5G down) Vertical position down

Disclaimer

All figures in this datasheet should be considered indicative only. No guarantee is made as to their accuracy.

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